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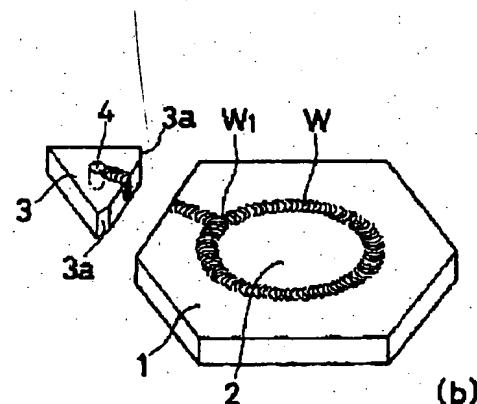
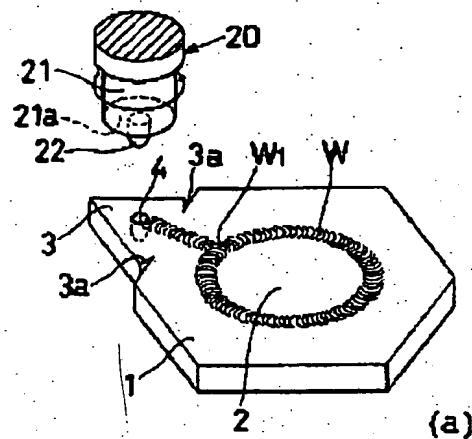
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TITLE : FRICTION STIRRING JOINING
METHOD.



ABSTRACT : PROBLEM TO BE SOLVED: To provide a method causing no holes or recesses after a probe is pulled out in a friction stirring joining method for joining members having such parts to be joined as the ending part returns to the starting part.

SOLUTION: A rotating probe 22 is inserted into a part to be joined of members 1, 2 and moved along the joining part with the probe 22 inserted while the part in contact with the probe is softened by frictional heat and stirred. When the probe 22 returns to the starting part W1 of joining, it is made to change in the moving direction and moved to the part 3 to be discarded that is provided at a position other than the joining part of the members 1, 2. Then, the probe 22 is pulled out of the part 3 to be discarded, with the part 3 cut off and removed.

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